

Date: Wednesday, 3/26/2008 10:03:54 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	TUBE		
Job Number	38200					
Estimate Number	10488					
P.O. Number	:			Part Number	D32041	
This Issue	3/26/2008	S.O. No.	:	Drawing Number	D3204 REV A1	
Prsht Rev.	NC			Project Number	N/A	
First Issue	11	Type	MACHINED PARTS	Drawing Revision	A1	
Previous Run	35873			Material	:	
Written By	:			Due Date	4/4/2008	Qty: 4 Um: Each
Checked & Approved By	DAR-08-3-27					
Comment	Est:B 04.06.09 Change Step 6; remove Steps 7 & 8 KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6T0750W125	6061-T6 Tube .75 x .125W	
		Comment: Qty.: 0.5460 f(s)/Unit Total: 2.1840 f(s) 6061-T6 Tube Ø0.750" x 0.125W Material: 6061-T6/T62 (QQ-A-200/8) Ø0.750" x 0.125" wall (M6061T6T0.750W.125) Batch: M18496	 08/04/14 ④
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL 1-Turn tube as per Folio FA356 and Dwg D3204 2-Deburr	 08/04/14 ④
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	 08/04/14 ④
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	 08/04/14 ④
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8/4/15	 08/04/14 ④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 10:03:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 38200

Part Number: D32041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/16 AF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38200
Description: Tube	Part Number:	D3204-1
Inspection Dwg: D3204	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

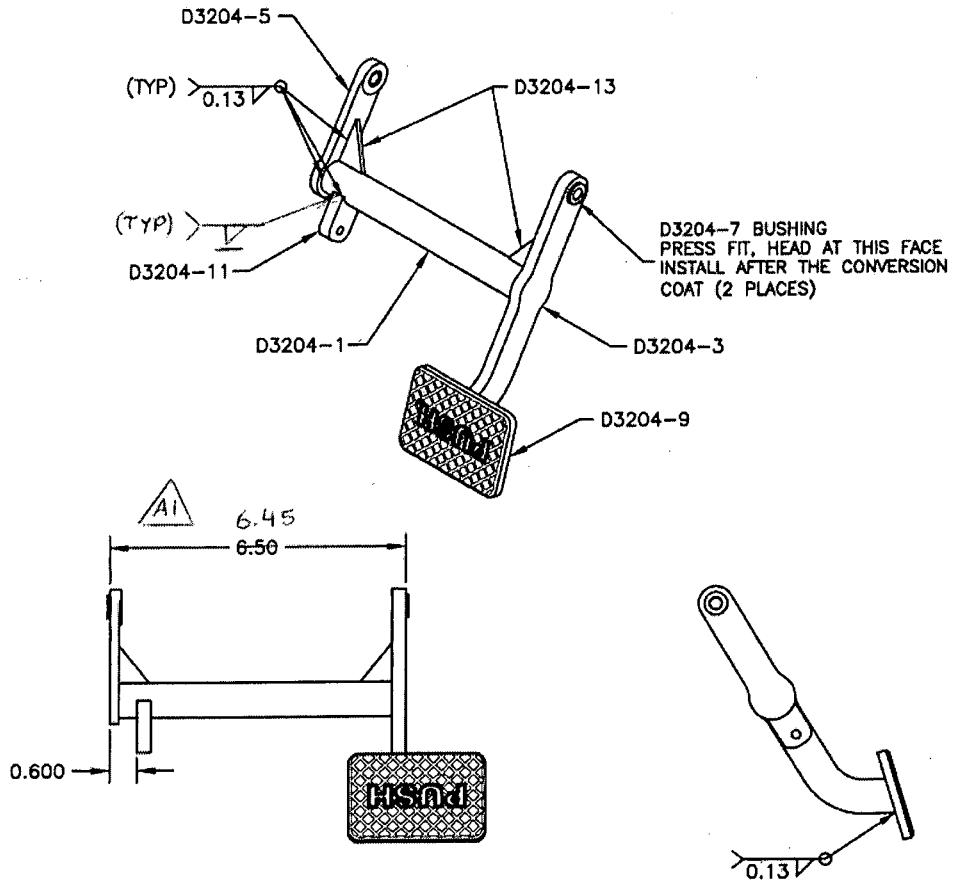
Measured by:		Audited by:		Prototype Approval:	N/A
Date:	08/04/14	Date:	08.04.14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	06.03.21	Dwg Rev update	KJ/JLM	

54

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3204	SHEET 1 OF 3
DATE		TITLE	SCALE
04.01.27		RELEASE PEDAL ASSEMBLY	NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30**D3204-041 RELEASE PEDAL ASSEMBLY****NOTES**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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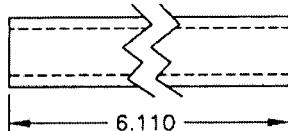
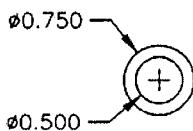
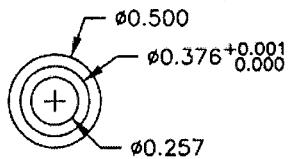
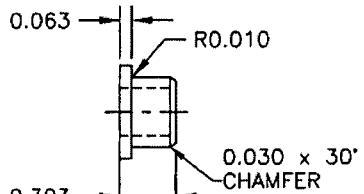
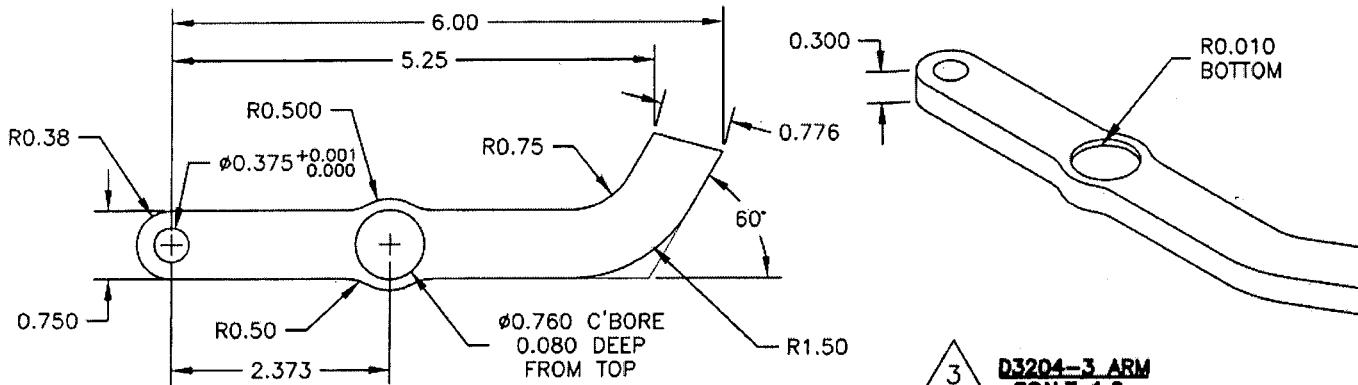
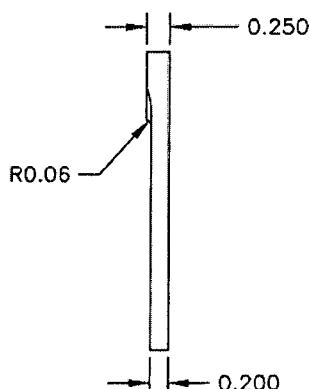
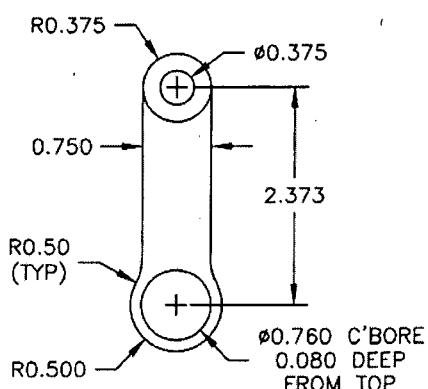
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

RELEASED
04.04.052 D3204-1 TUBE
SCALE 1:24 D3204-7 BUSHING
SCALE 1:13 D3204-3 ARM
SCALE 1:2

3 D3204-5 ARM
SCALE 1:2

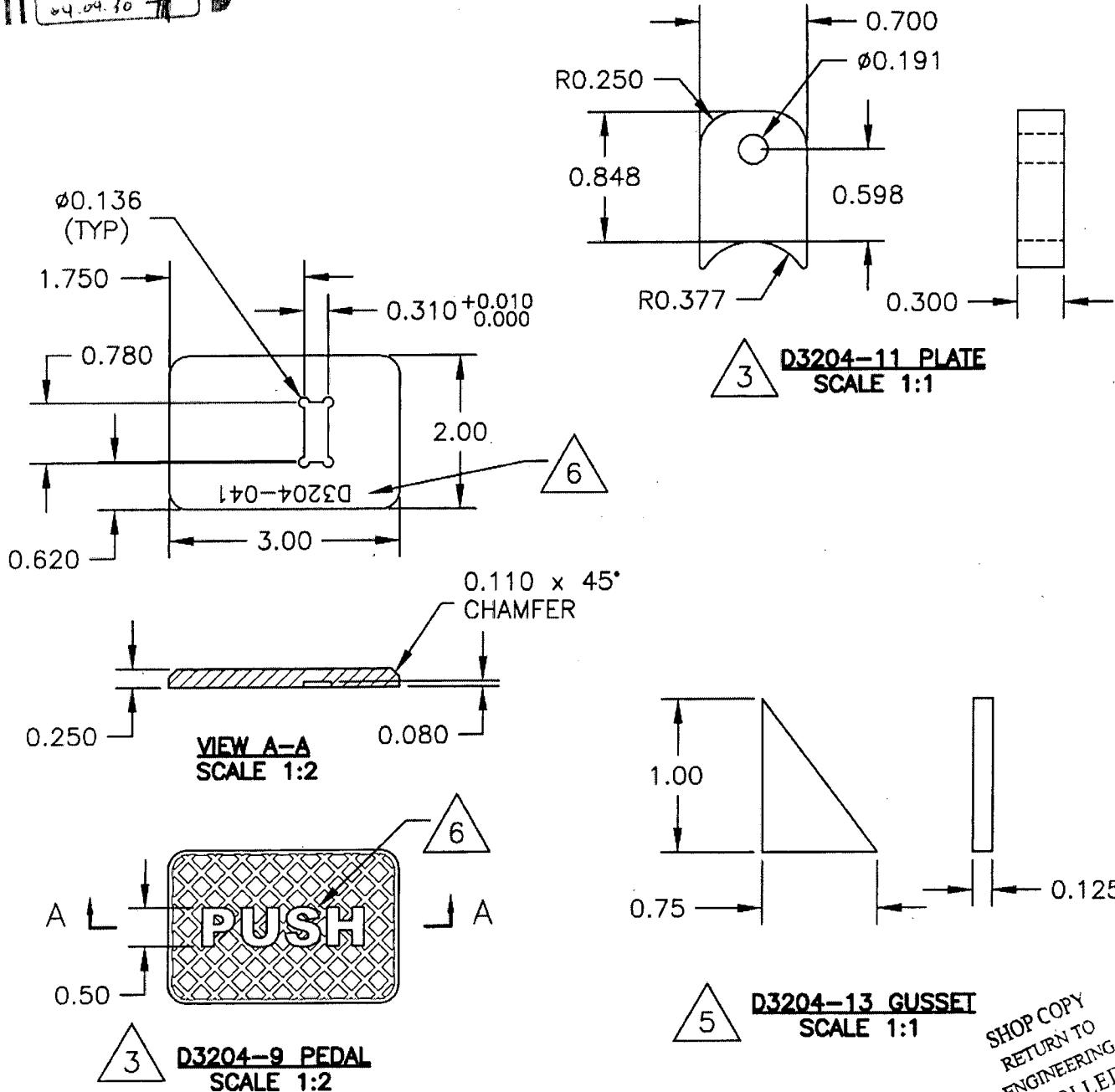
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DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY	REV. A SHEET 3 OF 3 NTS

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04.04.70

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